

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013360**Date Inspected:** 11-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huang Ming**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

**Bay#5**

During random Quality Assurance Visual review of welds located on Cable Tray components, this Quality Assurance Inspector (QA) discovered the following issues:

- Eight (8) linear indications measuring approximately 6~12 mm in length.
- The indications are clearly marked on the material near the welds.
- The item drawing numbers are designated as: CTS4D1-I3, CTS4D1-I4, CTS4D-A4, CTS4D-J3 and CTS4D-C4.
- These welds are fillet welds, utilized in the fabrication and joining the Cable Tray components.
- These Cable Trays are located in OBG Bay # 5.
- These indications were discovered visually by a Caltrans QA inspector during verification.

The Notice of Witness Inspection Number (NWIT) is 005500. The indications are located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

For further information, please see the attached pictures below. Please see incident report on this date.

**Bay#6**

SMAW welding of weld joint WJF-0-170 located on West Jacket Frame. Welder is identified as 066261 (2G).

ZPMC QC is identified as Zhang Sheng Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-3212-Tc-U4c.

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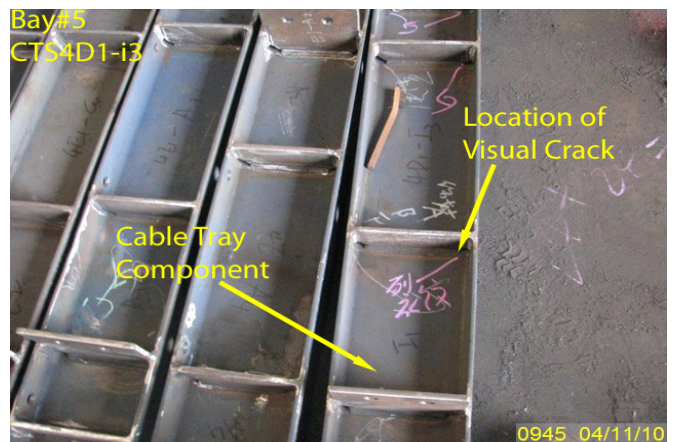
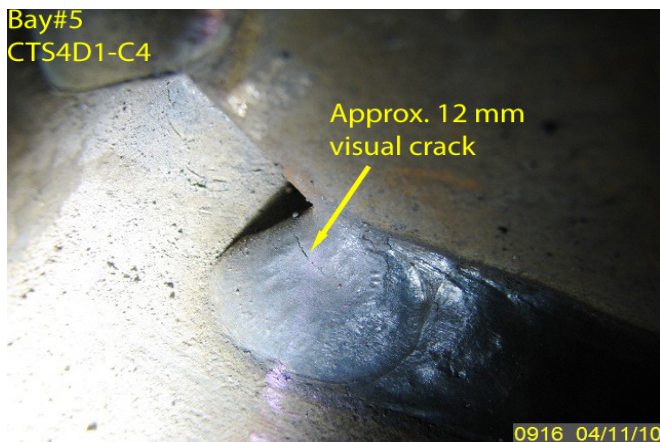
SMAW welding of weld joint WJF-0-306 located on West Jacket Frame. Welder is identified as 053753 (2F). ZPMC QC is identified as Zhang Sheng Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-3112-1.

SMAW welding of weld joint WJF-0-174 located on West Jacket Frame. Welder is identified as 067707 (2F). ZPMC QC is identified as Zhang Sheng Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-3112-1.

SMAW welding of weld joint WJF-0-415/416 located on West Jacket Frame. Welder is identified as 049769 (2F). ZPMC QC is identified as Zhang Sheng Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-3112-1.

SMAW welding of weld joint WJF-0-242 located on West Jacket Frame. Welder is identified as 048800 (2F). ZPMC QC is identified as Zhang Sheng Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-3112-1.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.



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### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Patel,Hiranch	Quality Assurance Inspector
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<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer
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